

LASER SURFACE MODIFICATION OF CR-MO POWDERS ON GREY CAST IRON FOR SURFACE PROPERTIES IMPROVEMENT

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Doctor of Philosophy (Mechanical Engineering)

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ABSTRAK

Kebelakangan ini dalam industri, komponen yang dihasilkan daripada besi tuang kelabu (seperti lapisan silinder dan disk brek) mengalami kecatatan kehausan dan kekaratan disebabkan oleh suhu yang tinggi, tekanan dan geseran yang menyumbangkan kepada pelbagai keadaan yang tegang. Tujuan kajian ini ialah untuk mengenalpasti dan membuat perubahan pada permukaan besi tuang kelabu dengan menggunakan kaedah mod proses laser nadi. Untuk mengukuhkan permukaan tersebut penambahan sebatian Cr-Mo diletakkan di atas permukaan. Hubungan parameter untuk proses ini dianalisis dengan menggunakan analisis statistik. Saringan awal rekabentuk eksperimen telah membawa kepada lebih banyak penemuan untuk mengoptimumkan rekabentuk dengan lebih terperinci. Dalam kajian ini, Laser Nd:YAG sistem model 300HPS dengan panjang gelombang $10.64\text{ }\mu\text{m}$ telah digunakan. Kajian awalan telah dilakukan dengan menggunakan rekabentuk model eksperimen 2 peringkat faktor pada laser cairan permukaan dengan saiz laser 1.0 mm, 1.2 mm, 1.4 mm dan 1.7 mm. Kajian awalan ini adalah untuk mengenalpasti parameter laser yang optimum dan saiz laser yang sesuai untuk menghasilkan bentuk geometri, kekasaran dan kekerasan yang baik pada besi tuang kelabu. Berdasarkan pada pengoptimuman laser parameter dalam laser cairan, saiz laser 1.0 mm dengan P_p , PRF dan S diantara 800 hingga 1200 W, 80 hingga 90 Hz dan 19.2 hingga 21.6 mm s^{-1} digunakan. Kemudian, eksperimen yang komprehensif dengan menggabungkan komponen campuran Cr dan Mo bersama faktor proses telah digunakan dalam proses laser pelapisan permukaan. Kedua-dua pemprosesan laser ini dibantu oleh gas argon pada kelajuan malar 10 L min^{-1} . Sampel yang telah di laser disediakan untuk kajian metalografi dan dicirikan untuk menentukan sifat fizikal dan mekanikal. Kajian metalografi dan analisis komposisi kimia dijalankan menggunakan mikroskop pengimbas elektron yang disepadukan dengan spektroskopi sinar-x penyebaran tenaga. Sistem XRD dengan radiasi Cu $K\alpha$ dan panjang gelombang $1.54\text{ }\text{\AA}$ digunakan untuk mengesan kristal dan fasa permukaan yang telah diubah dengan laser. Profil permukaan diukur menggunakan sistem pengukur profilometri stylus. Manakala sifat kekerasan permukaan yang telah diubah diukur dengan menggunakan lekukan berlian mikro-Vickers. Lapisan permukaan besi tuang kelabu yang telah diubah suai dengan tambahan lapisan campuran Cr-Mo telah menunjukkan penghapusan grafit dan pembentukan struktur baru dendritik dengan saiz pembentukan zarah pada saiz 32 nm. Fasa karbida juga telah dikesan di permukaan yang terdiri daripada M_2C , M_3C_2 and $M_{23}C_6$. Kekerasan maksimum yang telah diubah suai pada besi tuang kelabu ialah $1039.7\text{ HV}_{0.1}$ pada parameter laser 1200 W, 80 Hz dan campuran 32.3% Cr dan 67.7% Mo. Satu lagi penemuan yang penting dalam kajian ini ialah rintangan haus telah meningkat dengan membuat lapisan campuran Cr-Mo di permukaan besi tuang kelabu. Hubungan antara parameter laser dan tambahan campuran Cr-Mo dibangunkan untuk pemahaman lebih lanjut tentang kesan parameter laser pada campuran Cr-Mo. Penemuan ini penting bagi menghasilkan teknik pengerasan permukaan untuk tujuan rintangan haus, pengoksidaan dan rintangan haba terutamanya untuk komponen pelapik silinder dan cakera brek.

ABSTRACT

Recently, in industrial area, grey cast iron component parts (such as cylinder liner and break disc) experienced wear defect and corrosion due to the usage in high temperature, pressure and mechanical friction, which contribute to multifaceted, high-stress condition. The purpose of this research is to develop a modified surface layer on grey cast iron using laser melting and laser cladding. To strengthen the surface, Cr-Mo powder were added on the surface. The parameter on this process were analyzed using statistical analysis. The presented work is an investigation and modification of the laser surface of grey cast iron using pulse laser processing mode. Initial screening experimental designs was conducted and lead to more optimized detailed designs. A laser Nd:YAG system 300HPS model with 10.64 μm wavelength was used. Preliminary experiment of design of experiment 2-level factorial model were conducted in laser surface melting grey cast iron with spot size 1.0 mm, 1.2 mm, 1.4 mm and 1.7 mm to investigate optimized laser parameter and suitable spot size for the surface geometry, surface roughness and hardness. Based on the optimization laser parameter in laser surface melting, laser spot size of 1.0 mm with PP, PRF and S in range of 800 to 1200 W, 80 to 90 Hz and 19.2 to 21.6 mms^{-1} were used in laser surface cladding respectively. A comprehensive experiment that combines mixture components of Cr and Mo with process factor were used in laser surface cladding. The laser processing was constantly assisted by in line argon gas at 10 Lmin^{-1} . Laser processed samples were prepared for metallographic study and were characterized for physical and mechanical properties. The metallographic study and chemical composition analysis were conducted using scanning electron microscope integrated with energy dispersive x-ray spectroscopy. The crystallinity and phase detection of the modified surface were conducted using an XRD system with Cu K α radiation and wavelength of 1.54 Å. The surface profile was measured using stylus profilometry measuring systems. The hardness properties of the modified surface were measured by micro-Vickers diamond indentation. A modified surface layer (Cr-Mo mixture added) had shown the elimination of graphite and a new structure of dendritic with the formation of particles in size of 32 nm had developed. A new phase of carbide was also detected on the surface which mainly contained of M_2C , M_3C_2 and M_{23}C_6 . A maximum hardness modified grey cast iron of 1039.7 $\text{HV}_{0.1}$ is achieved at laser surface cladding parameter at 1200 W, 80 Hz and mixture of 32.3 % Cr and 67.7 % Mo. Another important finding was that wear resistance increases by adding the mixture of Cr and Mo on the grey cast iron surface. A relationship between laser surface parameter and mixture of Cr and Mo was established for further understanding of the effects of the laser parameters. These findings are significant to the establishment of surface hardening technique for wear resistance, oxidation and thermal resistance for cylinder liner and break disc.

TABLE OF CONTENT

DECLARATION	
TITLE PAGE	
ACKNOWLEDGEMENTS	ii
ABSTRAK	iii
ABSTRACT	iv
TABLE OF CONTENT	v
LIST OF TABLES	ix
LIST OF FIGURES	xi
LIST OF SYMBOLS	xv
LIST OF ABBREVIATIONS	xvi
CHAPTER 1 INTRODUCTION	1
1.1 Research Background	1
1.2 Problem Statement	3
1.3 Research Objective	5
1.4 Research Scope	6
1.5 Thesis Outline	6
CHAPTER 2 LITERATURE REVIEW	8
2.1 Introduction	8
2.2 Grey Cast Iron Advancement	8
2.2.1 Failure in Grey cast iron	10
2.2.2 Cladding with Cr and Mo	14

2.3	Advanced Surface Modification on Grey Cast iron	20
2.3.1	Laser Surface Melting of Grey cast Iron	24
2.3.2	Laser Cladding of Grey Cast Iron	28
2.4	Laser Surface Modification Parameter	32
2.4.1	Laser Beam Density and Interaction Time	32
2.4.2	Laser Spot Size	38
2.4.3	Laser Power and Traverse Speed	40
2.4.4	Laser Nd:YAG System	44
2.5	Pre-Placed Powder on Substrate Surface	45
2.6	Design of Experiment	49
2.7	Summary	51
CHAPTER 3 METHODOLOGY		54
3.1	Introduction	54
3.2	Material Preparation	56
3.3	Preliminary Experiment: Laser Surface Melting	57
3.4	Experiment for Laser Surface Cladding	59
3.4.1	Sample Preparation for Laser Cladding	60
3.4.2	Mixture Design of Experiment	61
3.5	Laser Nd:YAG System	63
3.6	Laser Spot Size	64
3.7	Characterizations Techniques	65
3.7.1	Sample Preparation	66
3.7.2	Metallographic Study	67
3.7.3	Microhardness Test	68
3.7.4	Surface Profilometry	69

3.7.5	X-ray Diffraction Analysis (XRD)	69
3.7.6	Energy Dispersive Spectrometer (EDS)	70
3.8	Sliding Wear Experiment	70
3.9	Statistical Analysis	72
CHAPTER 4 RESULT AND DISCUSSION		75
4.1	Introduction	75
4.2	Preliminary Findings of Laser Surface Melting on Grey Cast Iron	77
4.2.1	Metallography Study	78
4.2.2	Surface Geometry	80
4.2.3	Surface Properties of Laser Melted Grey Cast Iron	83
4.2.4	X-ray diffraction for laser surface melting	87
4.2.5	ANOVA for Laser Surface Melting of Grey Cast Iron	89
4.3	Laser Surface Cladding of Grey Cast Iron	93
4.3.1	Metallographic Study	94
4.3.2	X- ray diffraction for laser surface cladding	97
4.3.3	Energy Dispersive Spectrometer Analysis	100
4.3.4	Hardness Properties	103
4.3.5	Surface Profile	106
4.4	Statistical Analysis	108
4.4.1	ANOVA for Laser Cladding	108
4.4.2	Optimization Laser Cladding	112
4.5	Laser Surface Cladding from Optimisation Parameter	115
4.5.1	Sliding Wear Test	115
4.6	Summary Result and Findings	120

CHAPTER 5 CONCLUSION	123
5.1 Introduction	123
5.2 Conclusion	123
5.3 Future Work	125
REFERENCES	127
APPENDIX A LASER SURFACE MELTING PARAMETER AT SPOT SIZE 1.0 MM AND 1.2 MM	137
APPENDIX B LASER SURFACE MELTING PARAMETER AT SPOT SIZE 1.4 MM AND 1.7 MM	138
APPENDIX C ARDUINO PROGRAMME	139
APPENDIX D DESIGN SOLUTION IN DOE LASER SURFACE MELTING AT SPOT SIZE 1.0 MM AND 1.2 MM	142
APPENDIX E DESIGN SOLUTION IN DOE LASER SURFACE MELTING AT SPOT SIZE 1.4 MM	143
APPENDIX F DESIGN SOLUTION IN DOE LASER SURFACE MELTING AT SPOT SIZE 1.7 MM	144
APPENDIX G LIST OF PUBLICATIONS	145

LIST OF TABLES

Table 1.1	Summary report on gray cast iron failure.	4
Table 2.1	Characteristics of alloy carbide in steels.	15
Table 2.2	Advantage laser surface melting and laser cladding in cast iron.	23
Table 2.3	Previous researcher used laser surface melting at different setting for cast iron.	28
Table 2.4	Dimensions and average hardness of laser surface melting processed at different conditions.	44
Table 2.5	Paint technique used from previous researcher.	46
Table 2.6	Summary Literature review findings in grey cast iron modification with Cr and Mo.	53
Table 3.1	Chemical composition of HT250 grey cast iron.	56
Table 3.2	Summary of parameter settings for laser melting in low and high range for each laser spot size.	59
Table 3.3	Parameter setting for laser surface cladding of grey cast iron at spot size 1.0 mm.	62
Table 3.4	Laser Nd:YAG system 300HPS specification.	64
Table 3.5	Technique used to characterise the laser processed samples.	66
Table 3.6	Sliding wear test parameter setting.	72
Table 4.1	Molten pool radius on grey cast iron surface resulted from different laser.	82
Table 4.2	Microhardness and cooling rate of the melting zone laser surface melting range at four different spot sizes.	87
Table 4.3	ANOVA results for modified surface roughness response.	90
Table 4.4	ANOVA results for modified surface hardness response.	91
Table 4.5	Constraints in design optimization for laser surface melting.	92
Table 4.6	Processing parameter setting based on high desirability for spot size 1.0 mm, 1.2 mm, 1.4 mm and 1.7 mm.	93
Table 4.7	Chemical composition of the gary cast iron substrate analysed from selected area.	100
Table 4.8	Composition analysis for laser clad samples.	102
Table 4.9	Microhardness of cladding zone at spot sizes 1.0 mm.	105
Table 4.10	Surface roughness of clad zone at spot sizes 1.0 mm.	107
Table 4.11	ANOVA results for modified surface roughness response laser cladding.	109
Table 4.12	ANOVA results for modified surface hardness response laser cladding.	111

Table 4.13	Constraints in design optimization with microhardness were maximized and surface roughness was minimized.	113
Table 4.14	Predicted parameters for laser cladding of grey cast iron.	113
Table 4.15	Summary of laser parameters setting ranges and characterization results for factorial model and mixture model.	122

LIST OF FIGURES

Figure 2.1	Microstructure of the HT250 grey cast iron. (a) Unetched and (b) etched.	9
Figure 2.2	Presence of the worn surface on grey cast iron surface.	11
Figure 2.3	Morphology of the worn surface of cast iron with squeeze phenomena (indicated by the small arrow) and the escape of graphite to the surface.	12
Figure 2.4	Microcosmic place of crack (a) initiation and (b) propagation.	12
Figure 2.5	Front view of the crack found in cylinder liner engine diesel.	13
Figure 2.6	Fe-Cr-C liquid projection.	16
Figure 2.7	X-ray diffraction laser cladding Cr addition.	17
Figure 2.8	Wear resistance of grey cast iron with % wt. of molybdenum additions.	18
Figure 2.9	SEM images of the worn surface (a) before wear test and (b) after wear test.	18
Figure 2.10	Pin-on-disc test and hardness test result for the modified cast iron alloys with addition of chromium and molybdenum.	19
Figure 2.11	(a) Thermal shock resistance and (b) ultimate tensile strength of the alloyed grey cast iron as a function of alloyed composition.	20
Figure 2.12	Spectrum of laser application in surface processing.	22
Figure 2.13	The microstructure of melting zone in cast iron.	25
Figure 2.14	The microstructure of molten zone at different energy (a) 5.22 J, (b) 7.09 J, (c) 9.26 J, (d) 12.54 J and (e) 10.87 J.	26
Figure 2.15	(a) The microhardness in depth, (b) the equiaxed crystal grains at the top of molten pool and (c) the columnar crystal grains at the bottom of molten pool.	27
Figure 2.16	Schematic steps involved during the laser surface cladding.	30
Figure 2.17	Cross section of single (a) double (b) triple and (c) clad layer made by overlapping of single laser tracks.	31
Figure 2.18	The range of laser process mapped against laser beam density and interaction time. The diagonal lines represent the lines of constant temperature for the boiling and melting point of iron.	33
Figure 2.19	Laser beam power density (irradiance) treatment parameter variants that caused remelting/alloying in the surface layer of grey cast iron.	34
Figure 2.20	Variation of melt depth with power and time of laser material interaction.	34
Figure 2.21	Transverse cross-section of melted tracks for the following laser processing parameter: $P = 780 \text{ W}$, $d = 0.6 \text{ mm}$, $\tau = 0.01 \text{ s}$ and (a) $V = 0.8 \text{ mm/s}$, (b) $V = 1.6 \text{ mm/s}$, (c) $V = 5 \text{ mm/s}$ and (d) 40 mm/s .	35

Figure 2.22	The microstructure of laser surface melting (a) (c) (e) and laser surface alloying (b) (d) (f) at different energy density 10.7 Jmm^{-2} , 6.84 Jmm^{-2} and 4.75 Jmm^{-2} .	36
Figure 2.23	Effect of incident energy intensity on surface hardness properties.	37
Figure 2.24	Microhardness of laser melting (LSM) and laser alloying (LSC) in various energy density at load of 0.2 kg and a dwell time of 10 s.	38
Figure 2.25	Gaussian irradiance profile.	39
Figure 2.26	Growth in beam diameter as a function of distance from beam waist.	40
Figure 2.27	Calculated surface temperature and cooling rate as function of laser power and energy density.	41
Figure 2.28	Effect of heat input on the depth of modified layer and the surface roughness of the laser modified surface.	42
Figure 2.29	Laser tracks cross section for side cladding on grey cast iron. Combined parameter of laser power and fed material per unit track length (F/S).	43
Figure 2.30	Nd:YAG laser diagram.	45
Figure 2.31	SEM images of cross section the coatings: (a) 0.47 mm, (b) 0.74 mm, (c) 0.92 mm, (d) 1.09 mm, (e) 1.36 mm and, (f) 1.62 mm.	48
Figure 2.32	The space factor for a mixture experiment with three components in it.	51
Figure 3.1	Overall research methodology flowchart.	55
Figure 3.2	Sample size for (a) laser surface processing and (b) sliding wear test.	57
Figure 3.3	Linear sample movement in laser surface processing.	58
Figure 3.4	SEM image for (a) chromium powder and (b) molybdenum powder.	60
Figure 3.5	The schematic drawing of the preparation process of the preplaced layers.	61
Figure 3.6	Laser Nd:YAG machine.	63
Figure 3.7	Laser spot size at peak power 1 W on black paper, (a) 1 mm, (b) 1.2 mm, (c) 1.4 mm and (d) 1.7 mm.	65
Figure 3.8	Schematic indentation of Vickers hardness test.	68
Figure 3.9	Arithmetic average roughness value R_a .	69
Figure 3.10	Schematic diagram sliding wear test.	71
Figure 4.1	Outline of order of results presented in this chapter.	76
Figure 4.2	Pulse energy as a function of residence time for laser surface melting of grey cast iron at different laser spot sizes.	77
Figure 4.3	Comparison of previous work's in pulse energy versus laser spot size with this research.	78
Figure 4.4	Micrograph of grey cast iron with graphite and pearlite microstructure.	79

Figure 4.5	Micrograph of cross section (a) laser surface melting layer and (b) microstructure of grey cast iron surface melting zone.	80
Figure 4.6	Surface geometry of samples processes at spot size (a) 1.0 mm; (b) 1.2 mm; (c) 1.4 mm and (d) 1.7 mm.	82
Figure 4.7	High energy setting in laser surface melting effect at different spot size on surface roughness of melting zone.	84
Figure 4.8	Average hardness properties as a function of distance from surface for samples processed using spot size of 1.0 mm, 1.2 mm, 1.4 mm and 1.7 mm.	85
Figure 4.9	Residence time effect on hardness of laser surface melting grey cast iron at different laser spot sizes.	86
Figure 4.10	(a) X-ray diffraction as-received grey cast iron and (b) surface melting of grey cast iron.	88
Figure 4.11	Micrograph of laser cladding grey cast iron microstructure with addition of (a) Cr powder, (b) Mo powder and (c) Cr-Mo mixture powder.	95
Figure 4.12	Particle analysis in clad zone of grey cast iron with addition of (a) Cr, (b) Mo and (c) Cr-Mo mixture.	97
Figure 4.13	X-ray diffraction pattern for (a) grey cast iron substrate, (b) Cr-added clad, (c) Mo-added clad and (d) Cr-Mo mixture clad zone.	99
Figure 4.14	Selected area in grey cast iron substrate.	101
Figure 4.15	EDS qualitative analysis spectrum of phase for grey cast iron substrate.	101
Figure 4.16	Selected area in laser clad zone of (a) Cr, (b) Mo and (c) Cr-Mo mixture.	102
Figure 4.17	EDS qualitative analysis spectrum of phases for modified layer (a) Cr clad, (b) Mo clad and (c) Cr-Mo mixture clad.	103
Figure 4.18	Hardness properties of laser cladding surface with addition of Cr, Mo and Cr-Mo mixture as a function of distance from surface all cladding samples were processed at spot size 1.0 mm.	104
Figure 4.19	Micrograph of formation clad layer on grey cast iron substrate.	107
Figure 4.20	Contour plot of peak power and mixture component on surface roughness of clad zone at constant (a) 80 Hz and (b) 90 Hz.	110
Figure 4.21	Contour plot of peak power and mixture component on microhardness at constant (a) 80 Hz and (b) 90 Hz PRF.	112
Figure 4.22	Counter plot of design for laser surface cladding process optimization of grey cast iron at 1.0 mm laser spot size.	114
Figure 4.23	As-received grey cast iron and laser surface cladding layers result in (a) coefficient of friction (b) surface roughness and (c) weight loss.	117
Figure 4.24	Micrograph of the worn surface after the wear sliding test at 17.5 N. (a) as-received grey cast iron and (b) Cr-Mo mixture clad zone.	118

Figure 4.25 Wear rate at different load on as-received grey cast iron and laser clad sample.

119

LIST OF SYMBOLS

E_P	Pulse energy
τ	Pulse width or pulse duration
S	Scan speed
d	Laser spot diameter
P_P	Peak power
T	Pulse period
z	Distance from focal position
I	High power density or laser irradiance
F	Energy density
P_{ave}	Power average
T_R	Residence Time or interaction time
η	Overlapped
λ	Laser wavelength
M^2	Beam quality
H_R	Heating rate
C_R	Cooling rate
$t_{cooling}$	Cooling period
μ	Coefficient of friction
N	Number of cycle
t	Times
f	Frequency
x	Total sliding distance
L	Length of stroke

LIST OF ABBREVIATIONS

ASTM	American Society for Testing and Materials
ANOVA	Analysis of variance
Ar	Austenite
COD	Crystallography open database
CoF	Coefficient of friction
DOE	Design of experiment
EDS	Energy dispersive spectrometer
GCI	Grey cast iron
HV	Hardness Vickers
HAZ	Heat affected zone
LSM	Laser Surface Melting
LSC	Laser surface cladding
Nd:YAG	Neodymium-doped yttrium aluminium garnet
PRF	Pulse repetition frequency
RZ	Remelting zone
RPM	Revolution per minutes
RSM	Response Surface Methodology
SEM	Scanning electron microscopy
TZ	Transform zone
TEM	Transverse electromagnetic mode
UV	Ultraviolet
XRD	X-ray diffraction

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